<b>Work Ord</b> February-24-14	er ID 113568 9:58:28 AM			*113	3568	3*		A	5PM	>			Page 1
Item ID: Revision ID:	D3589-11	p 35	89-11	Accept	*N	9ററ	040	100	)* :	-		*N:	S1*
Item Name:	Fwd Guide Plate	$B_J$	10							;	Stop	*N:	S2*
Start Date:	2/27/14 <b>Sta</b>	rt Qty: 6.00	*6*		Cu	st Item l	D:						
Required Date: Reference:	2/27/14 <b>Rec</b>	<b>l'd Qty:</b> 6.00	*6*		Cı	istomer:							
Approvals:	Process Plan:	<b>M</b> しゴ	Date: 1407-7	Y Tooling:		D	ate:	-	I		Start	*N	R1*
	QC:		Date:	SPC (Y/N):		D	ate:			ì	Stop	*N	R2*
Sequence ID/ Work Center II	-	ration cription	,	Set Up/ Run Hours	7	ool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		eject umber	Insp. Stamp
Draw Nbr	Revision	Nbr	i										
D3589	С												
100				0.00									. , ,
*100* Waterjet FLOW CNC Waterje	et	Memo Cut as per d Prog Rev:		0.00					<u>(b)</u>		mm	/E 19	1/01/4
		Dwg Rev:	<u> </u>										
110	QC2	- Inspect parts off m	achine FAI/FAIB	0.00					•				
*11 <b>0</b> *		- •	:						6	Y	nn/	<i>g</i> )'	1/04/21
QC		Memo		0.00							/~		7

Quality Control

DQA:			Date:												
						WORK ORDER NON	-CC	ONFO	RMANCE / UP	DATE					AEROSPACE
QA Closed:			Date:			·				,	Wc	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST I	DEI	PARTMENT	/PROCESS		
				_	Rework	1	Skid-tube Crosstube				Water Jet E			Engineering	
Part N	lo.					Scrap	1		Machining	Small Fab	╗	Pro	d. Eng. Coor.	╗	Quality
	•				_	Use-as-is	1	Thern	noforming	Finishing		Rec/Sto	re/Packaging		Other
NCR N	۱o. ِ					Suspected Unapproved	]		Large Fab	Composite[			Supplier		
Root					Desci	ription of work order update		nitial	Actio	on		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification		QC Inspector
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Doc/Data							ļ							1	
Equip/Tooling		•											:		
Handling/Pre															
Material							1							Ì	
Operator															
Offset/Setup							1								
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Supplier														İ	
Training															
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Unapproved														l	
							FA	ULT CA	TEGORY	. <u>.</u>					
Landi	ng (	Gear				General		,		,		1	_	_	
	_	Bending			$\perp$	Bend	L	1	Program			Outside Dim	<del> </del>	↤	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	<u></u>	Grain				Over/Under	tolerance	$\dashv$	Set-up
		Cracks			<u> </u>	Broken/Damage/Defect		Hardwa	are			Part Incorre	<b>⊢</b>	$\dashv$	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Und	qualified		Part Lost/Mi	issing	_	Weld
		Cuffs				Contamination		4	tions Incomplete/U	nclear		Part Moved	L		Wrong Stock Pulled
		Crushing				Countersink	$ldsymbol{ldsymbol{ldsymbol{ldsymbol{eta}}}$	-	gned/off center			Positioned V			
		Heat Trea	at			Cut Too Short		Mislab				Power Loss/	Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misrea					<u></u>		
	L	Marks/Ch	natter			Drill Holes	<u></u>	Off-set							
		Turning S	equence		<u> </u>	Finish		Out of	Calibration						
	Wave/Twist in Tube			Fit/Function		Out of	Sequence								

<u> </u>	18-7-				,					
Work Order ID 113. February-24-14 9:58:28 AM	568	:	*113	568*	<b>:</b>					Page 2
Item ID: D3589-11 Revision ID: Item Name: Fwd Guide Plate		ı	Accept	*N90	າດດ4ດ	100	)* s	Setup Sta		S1*
Start Date: 2/27/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust It	tem ID: ner:			545	* *N	S'2* ;
		î	_ 0 _		Date:		F	Run Sta Sto	^ <b>  \</b>	R1* R2*
Work Center ID	Operation Description QC8- Inspect parts - second check	1	Set Up/ Run Hours	Tool	ID Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*120* QC Quality Control	Мето	4 4 4	0.00 27 1447				<u> </u>			
*1120* Packaging Packaging	Identify as per dwg & Stock Locatio  Memo		0.00 0.00				Lox.		14-1	J-A.
140 <b>*イ泣↑*</b> OC Quality Control	QC21- Final Inspection - Work Order  Memo	r Release	0.00				M	ر <u>ح</u>	140	H-22

JH4-04-90

DAS 26 9-89

DQA:			Date:		<del></del>	WORK ORDER NON-CONFORMANCE / UPDATE								DART	
QA Closed:			Date:			WORK ORDER NON-	-CC	JNFOI	KIVIAINCE / UI		Nork C	rder ur	odate only		AEROSPACE
						DISPOSITION				1. III TUI		·			
Work Orde	er: .	·				DISPOSITION AGAINST DEPARTMENT/PROCESS									
						Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part I	٧o.					Scrap		-	Machining	Small Fab		Pro	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing	_  R	lec/Sto	re/Packaging		Other
NCR I	۷o.					Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desci	ription of work order update		nitial	Act	tion	Si	gn &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	(	Date	Verification	1	QC Inspector
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Equip/Tooling															
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		<del></del>					FAI	ULT CA	TEGORY						
Landi	$\overline{}$	1			_	General		1 .		г	_		r		1
	_	Bending				Bend		•	Program				ensions		Pressure/Forced
	L	Centre No	ot Concer	ntric		BOM/Route		Grain		<u> </u>		-	tolerance		Set-up
	<u> </u>	Cracks				Broken/Damage/Defect	<u></u>	Hardwa		Ļ	_	Incorre	· · · · · · · · · · · · · · · · · · ·		Temperature/Cure
	<u>_</u>	Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs		4 '	ion Incomplete/U	· -	—	Lost/M	- P		Weld
		Cuffs			_	Contamination	_	1	tions Incomplete/	Unclear		Moved	L		Wrong Stock Pulled
	Crushing		<u> </u>	Countersink	-	1 '	gned/off center	]_		tioned \			Ī		
	<u></u>	Heat Trea			<u> </u>	Cut Too Short	⊢	Mislabe		L	Pow	er Loss/	Surge		Other
	Inspection Strip in Tube			Drawing	<u></u>	Misrea									
	<u></u>	Marks/Ch	atter			Drill Holes		Off-set							
		Turning S			L	Finish	<u></u>	4	Calibration						
	Wave/Twist in Tube			Fit/Function		Out of	Sequence								

February-24-14 9:58:28 AM

Work Order ID: 113568

\*113568\*

**Parent Item:** 

D3589-11

\*D3589-11\*

Parent Item Name: Fwd Guide Plate

**Start Date: 2/27/14** 

Required Date: 2/27/14

Start Qty: 6.00

Required Qty: 6.00

**Comments:** 

IPP Rev:A 08-06-05 new issue DD verified by:ec 02-20 rev.b asper dwg DD verified by:EC

IPP Rev:B 09-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	217.1370	0.04	0.252632			
*M304S16	SGA*								**		mm	1	1/04/20
\1 <b>b</b>				Location	Ĺ	Loc	Qty	Loc Code					
W.				MAT020		217	7.137						

X

M126915 1.487 M127821 129.33 86.32

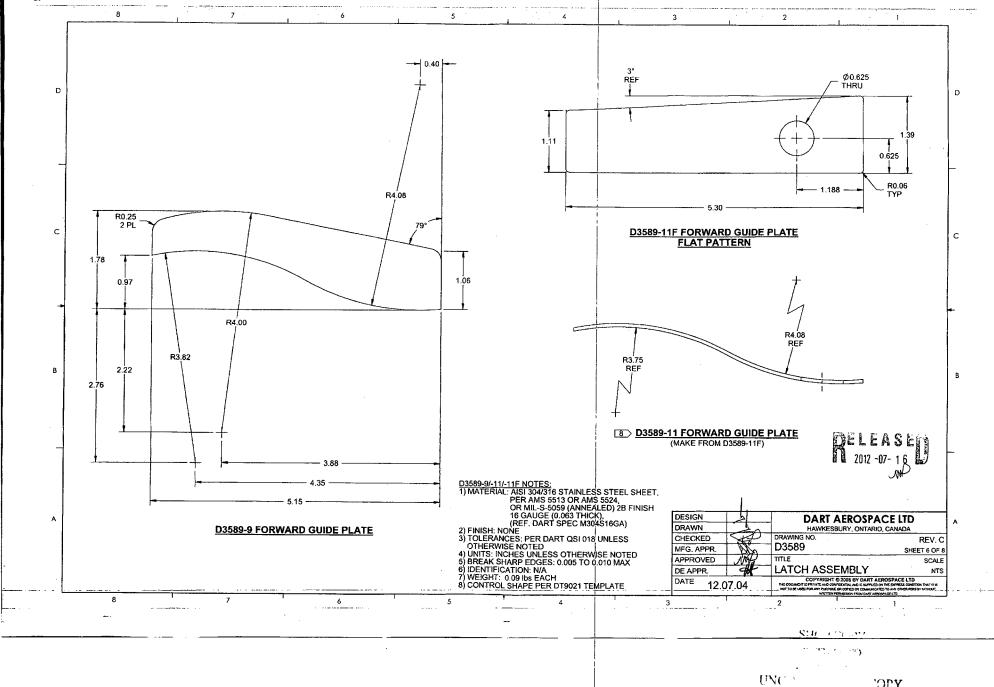
DQA:			Date:		TRAG $^{\prime\prime}$										
0.4.01			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		14/0	rk Ordor un	data only	7	AEROSPACE
QA Closed:			Date:				_				VVC	ork Order up	idate only		
Work Orde	er:					DISPOSITION				AGAINST I	DEF	PARTMENT	PROCESS		
	-					Rework			Skid-tube	Crosstube	$\neg$		Water Jet	7	Engineering
Part N	lo.					Scrap			Machining	Small Fab	ᅦ	Pro	d. Eng. Coor.	7	Quality
	•					Use-as-is			moforming	Finishing			e/Packaging	1	Other
NCR N	۱o.					Suspected Unapproved			Large Fab	Composite		·	Supplier		
Doot					Docc	ription of work order update		nitial	Actio	<b>an</b>	_	Sign &		T	
Root	- 1	Data	Ston	O+1/	Desc	or non-conformance		iiilliai iief Eng				Date	Verification		QC Inspector
Cause		Date	Step	Qty		or non-comormance	CII	ilei ciig	Descri	ption	$\dashv$	Date	Vermeation	+	QC IIISPECTOI
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Doc/Data															
Equip/Tooling Handling/Pre															
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Operator	H														
Offset/Setup															
Process															
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		Bending				Bend		Folio/i	Program	ļ		Outside Dim	ensions	-	ressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	┥.	et-up
,		Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorre	cí 📙	—	emperature/Cure
		Crimp/Kir	nk/Ripple	e/Wave		Burrs	L	Inspect	tion Incomplete/Und	qualified		Part Lost/Mi		-	Veld
		Cuffs				Contamination	_	4	tions Incomplete/U	nclear		Part Moved	_	\^	Vrong Stock Pulled
	Crushing		<u> </u>	Countersink	L	-	gned/off center			Positioned V		_			
	Heat Treat			Cut Too Short	_	Mislab				Power Loss/	Surge	0	ther		
	Inspection Strip in Tube		<u> </u>	Drawing		Misrea									
		Marks/Ch			L	Drill Holes		Off-set							
	Turning Sequence		<u></u>	Finish		4	Calibration								
	Wave/Twist in Tube			Fit/Function		Out of	Sequence								

DART AEROSPACE LTD	Work Order:	113568
Description: Fwd Guide Plate	Part Number:	D3589-11
. / /		
Inspection Dwg: D3589 Rev: 8 (1 C/L 1)		Page 1 of 1

mspection Dwg	•	ARTICLE IN	SPECTION	ON CHE	CKLIST		
	x	7	_	Proto			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
Ø0.625	+0.008/-0.001	0.625					
0.625	+/-0.010	0.625					
1.39	+/-0.030	1.39					
1.188	+/-0.010	1.188					
1.11	+/-0.030	1.19					
5.30	+/-0.030	5.30					
0.063	+/-0.010	0.063					
			i				
		-					
			DAG				
			27 /	<del>,                                    </del>			
	mm/EZ	Audited by:	9-89/	/	Prototype App		N/A
Date:	14/04/21	Date:	141416	<i>\</i>		Date:	N/A

Measured by: mm/7		59//	Prototype Approval:	N/A
Date: 14/04/21	Date: 14	14/2]	Date:	N/A

Rev	Date	Change	Revised	ÞУ∧	Approved
Α	09.05.07	New Issue	KJ/EC	941	W
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NO-113568MLJ 14-02-24

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